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**FACSIMILE TRANSMITTAL**

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**FROM:**

**Name:** Office of Patent Publication  
Certificate of Corrections Branch

**Name:** Thomas H. Martin

**Firm:** U.S. Patent & Trademark Office

**Phone No.:** 330-877-2277

**Fax No.:** 571-273-8300

**No. of Pages (including this):** 8

**Subject:** Request for Certificate of Correction

**Date:** June 27, 2007

U.S. Patent No. 7,225,856

Issued: June 5, 2007

Gerald Scott et al.

PRECIPITATION-HARDENABLE ALLOY CORE ROD,

PLUNGER TIP HAVING A UNIFORM SIDE WALL

THICKNESS, AND METHOD OF FORMING SAME

Attorney Docket No.: 117.0001-00000

Customer No. 22882

**Confirmation Copy to Follow: No**

**Message:**

**CERTIFICATE OF TRANSMISSION UNDER 37 CFR 1.8**

I hereby certify that the attached Request for Certificate of Correction with 1 sheet of Form PTO-1050 (in duplicate) and 3 pages of supporting documents are being facsimile transmitted to the U.S. Patent and Trademark Office on June 27, 2007.



Sandra L. Blackmon

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PATENT  
Attorney Docket No. 117.0001-00000  
Customer No. 22882

## IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

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In re U.S. Patent of: )  
Gerald Scott et al. ) (Serial No.: 10/633,919)  
Patent No.: 7,225,856 )  
Issue Date: June 5, 2007 ) (Filed: August 4, 2003)  
For: PRECIPITATION-HARDENABLE )  
ALLOY CORE ROD, PLUNGER TIP )  
HAVING A UNIFORM SIDE WALL )  
THICKNESS, AND METHOD OF )  
FORMING SAME )

Certificate of Correction Branch  
Commissioner for Patents  
P.O. Box 1450  
Alexandria, VA 22313-1450

Sir:

**REQUEST FOR CERTIFICATE OF CORRECTION**

Pursuant to 35 U.S.C. § 254 and 37 C.F.R. § 1.322, this is a request for the issuance of a Certificate of Correction in the above-identified patent. Two (2) copies of PTO Form 1050 are appended. The complete Certificate of Correction involves one (1) page.

The mistakes identified in the appended Form occurred through the fault of the Patent Office, as clearly disclosed by the records of the application which matured into this patent, and as evidenced in the attached copies of the following documents:

1. Pages 2 and 3 of the December 26, 2006 Amendment, showing the correct language of issued claims 4 and 11 (pending claims 9 and 16, respectively); and
2. Page 2 of the April 4, 2007 Notice of Allowability, showing the deletion of pending claim 21 (issued claim 12) by way of Examiner's Amendment.

JUL 3 2007

Issuance of the Certificate of Correction containing the correction is earnestly requested.

Respectfully submitted,

MARTIN & FERRARO, LLP

Dated: June 27, 2007

By: 

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PTO/SB/44 (04-05)  
(Also Form PTO-1050)UNITED STATES PATENT AND TRADEMARK OFFICE  
**CERTIFICATE OF CORRECTION**

PATENT NO. : 7,225,856  
APPLICATION NO. : 10/633,919  
ISSUE DATE : June 5, 2007  
INVENTOR(S) : Gerald Scott, et al.

Page 1 of 1

It is certified that an error appears or errors appear in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

Column 6:

Line 15: change "claim. 2," to -- claim 2, --;  
Line 38: change "step of." to -- step of pouring a beryllium-copper alloy. --;  
Lines 39-41: delete in their entirety; and  
Line 42: change "claim 12" to -- claim 10 --.

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PATENT NO. 7,225,856

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PATENT NO. 7,225,856

JUL 3 2007

Application No. 10/633,919  
Amendment dated December 26, 2006  
Reply to Office Action of June 26, 2006

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

Claims 1-5 (cancelled).

6. (original) A method of forming a core within a metal casting, the method comprising the steps of:
- providing a precipitation-hardenable alloy core rod having a length and opposite ends;
  - packing sand around at least one end of the core rod to form a sand core with core rod;
  - placing the sand core with core rod into a mold;
  - pouring molten non-ferrous metal into the mold and around the sand core with core rod; and
  - producing a non-ferrous metal casting having a core and a uniform sidewall thickness having a deviation in the thickness in a range of +/- 0.060 inches.
7. (original) The method of claim 6, wherein the providing step includes the step of providing a core rod being made from a precipitation-hardenable alloy comprising about 40.0 to 75.0 wt. % Ni, about 0.0 to 25.0 wt. % Co, about 10.0 to 25.0 wt. % Cr, and about 0.0 to 20.0 wt. % Fe.
8. (original) The method of claim 7, wherein the providing step includes the step of providing a rod core that does not stress relax during and after the pouring step.
- \* 9. (original) The method of claim 7, wherein the providing step includes the step of providing a rod core that remains straight during and after the pouring step. \*
10. (original) The method of claim 7, wherein the providing step includes the step of providing a rod core that does not bend during and after the pouring step.

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11. (original) The method of claim 7, further comprising the step of solidifying the metal in the mold and around the sand core with core rod to form the casting.
12. (original) The method of claim 11, wherein the providing step includes the step of providing a rod core that does not stress relax during the solidifying step.
13. (original) The method of claim 11, wherein the providing step includes the step of providing a rod core that remains straight during the solidifying step.
14. (original) The method of claim 11, wherein the providing step includes the step of providing a rod core that does not bend during the solidifying step.
15. (original) The method of claim 7, wherein the producing step includes the step of machining the casting into a plunger tip for use in one of aluminum and magnesium die casting operations.
- \* 16. (original) The method of claim 15, wherein the pouring step includes the step of pouring a beryllium-copper alloy. \*
17. (withdrawn) A beryllium-copper alloy plunger tip for use in aluminum and magnesium die casting operations formed by the method of claim 6.
18. (withdrawn) The plunger tip of claim 17, wherein the plunger tip comprises a cylindrical body closed at one end and having an axially extending cavity therein, said body having a generally uniform wall thickness determined by the distances of an interior surface and exterior surface of the body from the axis of the plunger tip at a predetermined point along the length of said plunger tip.
19. (withdrawn) The plunger tip of claim 18, wherein the body is internally threaded to enable the plunger tip to be connected to a rod.
20. (withdrawn) The plunger tip of claim 18, further comprising an adapter having a first end and an opposite second end, wherein the body is internally threaded to cooperatively engage said first end of said adaptor, said second end of said adapter being adapted to cooperatively engage a rod.
21. (previously presented) The method of claim 16, wherein the machining step includes the step of machining the casting into a plunger tip having a cylindrical

Application/Control Number: 10/633,919  
Art Unit: 1742

Page 2

### EXAMINER'S AMENDMENT

1. An examiner's amendment to the record appears below. Should the changes and/or additions be unacceptable to applicant, an amendment may be filed as provided by 37 CFR 1.312. To ensure consideration of such an amendment, it **MUST** be submitted no later than the payment of the issue fee.

Authorization for this examiner's amendment was given in a telephone interview with Mr. Thomas H. Martin on March 26, 2007.

The application has been amended as follows:

- \* I. Claims 17 to 21 drawn to a non-elected invention have been cancelled. \*
- II. In claim 6, line 8, the phrase, "non-ferrous" has been deleted.
- III. In claim 6, line 10, the phrase, "non-ferrous" has been deleted.
- IV. New claims 23, 25 and 26 have been canceled.

### *Amendment to the Drawings*

2. The following changes to the drawings have been approved by the examiner and agreed upon by applicant:

- I. Figure 2 will be labeled as "Prior Art in view of the disclosure in the specification at page 6, lines 3 to 6.

In order to avoid abandonment of the application, applicant must make these above agreed upon drawing changes.

JUL 3 2007